

Work Order ID 50762

July 21, 2009 2:40:09 PM



Page 1

Item ID: D2596

Accept



Setup Start



Revision ID: D

Stop



Item Name: Web, 205 Skidtube

Start Date: 07/22/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 07/31/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 09-07-21 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2596	Rev D

100 Skidtubes 0.00



Skidtubes

Memo

0.00

Skidtubes

1- Cut D2500-3-100 to length: 99.5" 12- Use Jig DT8093 to drill pilot holes
#30 13- Open to 0.630" diameter as per Dwg D2596 4- Deburr

10 *φ* - *AWM 8-8-10*

110 Chemical Conversion Coat per QS1005 4.1 0.00



HandFinish

Memo

0.00

Hand Finishing

10 *φ* - *AWM 8-8-10*

120 QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

⇒ 8 09/08/20

ATD

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start

QC:

Date:

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Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: L-G

0.00



Packaging

Memo

0.00

Packaging

10 0 - AWM 9-8-20

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/08/25

MF 09-08-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Work Order ID: 50762

Parent Item: D2596RevD

Parent Item Name: Web, 205 Skidtube



Comments:

Start Date: 07/22/2009

Required Date: 07/31/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2500-3-100RevU/R		Manufactured	No			100	Each	0.0000	10.0000			
										<i>B-40196 QWM 9-E-</i>		
Ext'n - I' Beam Web 4"												

B-40196 QWM 9-8-20

10

W/O:		WORK ORDER CHANGES					
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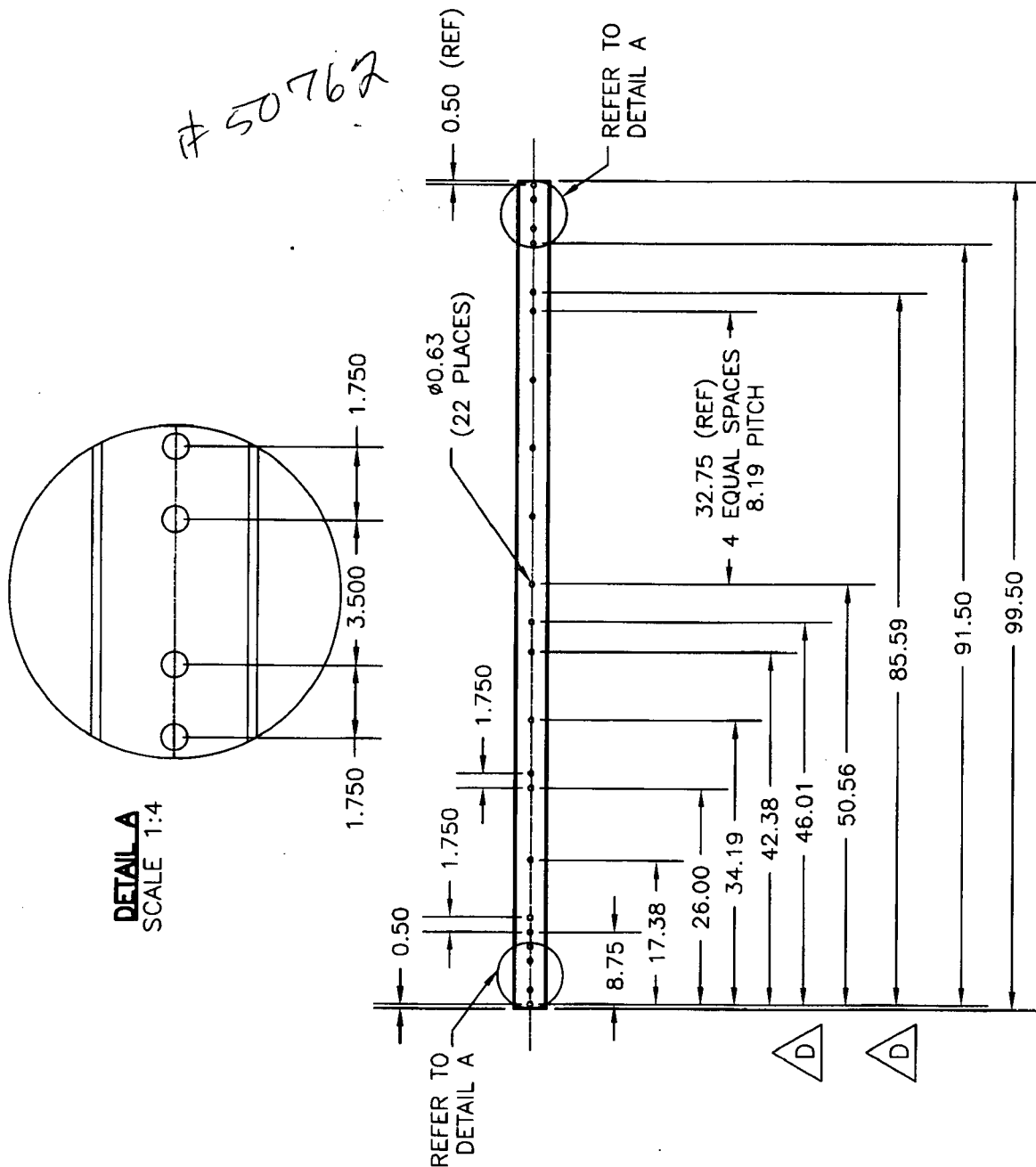
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DART**RELEASED**
07.06.18 #

DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2596	REV. D SHEET 1 OF 1
DATE 07.04.17		TITLE 205 WEB	SCALE 1:20
A	96.09.16	NEW ISSUE	
B	97.07.23	Ø0.63 HOLE WAS Ø0.56	
C	98.09.14	INCORPORATED DEO 9097	
D	07.04.17	INCORPORATED DEO 9183	



- D2596 WEB**
- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

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